

Date: Monday, 18/08/2008 10:21:33 AM
 Ser: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEAM ASSEMBLY
Job Number	: 41268		
Estimate Number	: 10407		
P.O. Number	:	Part Number	: D3173041
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: D3173 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 37157	Material	:
Written By	:	Due Date	: 21/08/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JLD 08.8.08</u>		
Comment	: Est. A 02.12.05 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6TR40X20W125

6061-T6 Rect Tube 4.0 x 2.0 x .125w



Comment: Qty.: 4.9219 f(s)/Unit Total : 9.8438 f(s)
 6061-T6 Rect Tube W.125

Material: 6061-T6 (QQ-A-200/8) Rect. Tube 4" x 2" x 0.125 thick
 (M6061-T6TR4.0x2.0W125)
 Batch M109025 ~~not in computer~~

JLD 08/08/28

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blank: 56" long
 Machine holes as per Folio FA295 and Dwg D3173
 Identify as D3173-1

JLD 08/08/25

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine holes as per Folio FA295 and Dwg D3173 Identify as D3173-1

N.A

08/08/30

PR

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A

08/08/30

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/09/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3173-041 PAR #: 11A Fault Category: Prod/Machined Part NCR: Yes No DQA: D Date: 08/09/25
D130-701-041 QA: N/C Closed: D Date: 08/09/25

NCR: 41268		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/30	3.0	Bad origin on Y axis The person before me forgot to remove .000" from the edge finder kicks one off on one side	<i>[Signature]</i> 08/09/25	SCRAP TUBE CP 0809.04 QTY 1. NO REPLUSE	D.A 08/08/30	<i>[Signature]</i> 08/09/25	<i>[Signature]</i> 08/09/25	<i>[Signature]</i> 08/09/25

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 10:21:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 41268

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

N.A

08/08/30

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S o e l o c u (1)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Ø0.316" holes as per Dwg D3173

C'sink holes as per Dwg D3173

FF 08-09-11

(1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S o e l o c u (1)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. h

08/09/16

(1X)

11.0

D3178041

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut Plate

Pick K10017. Install Nut Plate as per Dwg D3173. D3178-041 is included in K10017 BOM.

Pick:

Qty	Part Number	Description	Batch
2	D3178-041	Nut Plate	B24895B

FF 08/09/18

(1)

12.0

MS20601AD4W4

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Pick:

Qty	Part Number	Description	Batch
8	MS20601AD4W4	Rivet	19278

FF 08/09/18

(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 10:21:34 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 41268

Part Number: D3173041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/09/19 (X)

14.0 POWDER COATING POWDER COATING



M108523



(1X)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3
Ensure Nut Plate thread is covered.

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00
320 OF
12:30

M-1 08/09/19

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/08/09/22 (X)

16.0 D3175041 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Mounting Lug

Assemble per Dwg D3173. Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

Pick:

Qty	Part Number	Description	Batch
2	D3175-041	Mtg Lug	M24895C

B25025

SP

Missing
(1)

17.0 AN35A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN3-5A	Bolt	M19356

M100188

SP

(6)

18.0 AN523A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN5-23A	Bolt	M19278

M101013

8/19/19

SP

(1X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 10:21:34 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEAM ASSEMBLY

Job Number: 41268

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD10	Washer	M105442

SP

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	AN960JD516	Washer	M108672

SP

21.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L5	Nut	M108161

8/9/19

SP

22.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble per Dwg D3173.

Install Mounting Lug as per Dwg D3173. D3175-041 is included in K10017 BOM.

8/8/19

SP

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/8/19

SP

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as D3173-041 and Pack with D130-701-041

Location: 202

8/9/23

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: BEAM ASSEMBLY

Job Number: 41268

Part Number: D3173041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/24 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-09-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3173	REV. B SHEET 1 OF 3
DATE 03.01.07		TITLE BEAM ASSEMBLY	SCALE NTS
A	02.12.03	NEW ISSUE	
B	03.01.07	REMOVE PIP PINS	

PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3173-041	BEAM ASSEMBLY
1	D3173-1	BEAM
2	D3175-041	MOUNTING LUG
2	D3178-041	NUT PLATE
8	AN960JD10	WASHER
4	AN960JD516	WASHER
2	MS21042L5	NUT
8	MS20601AD4W4	RIVET
8	AN3-5A	BOLT
2	AN5-23A	BOLT

NOTES

D3173-1 BEAM:

- 1) PART IS SYMMETRICAL ABOUT CENTERLINE
- 2) MATERIAL: 6061-T6 RECTANGULAR TUBING, 4" x 2" x 0.125" WALL (QQ-A-200/8)
(REF DART SPEC. M6061T6TR4.0x2.0W125)
- 3) BREAK ALL SHARP EDGES 0.010-0.020
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 OUTSIDE ONLY
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

RELEASED
03.01.20 [Signature]

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WITHOUT NOTICE
WORK ORDER
NO. 41268

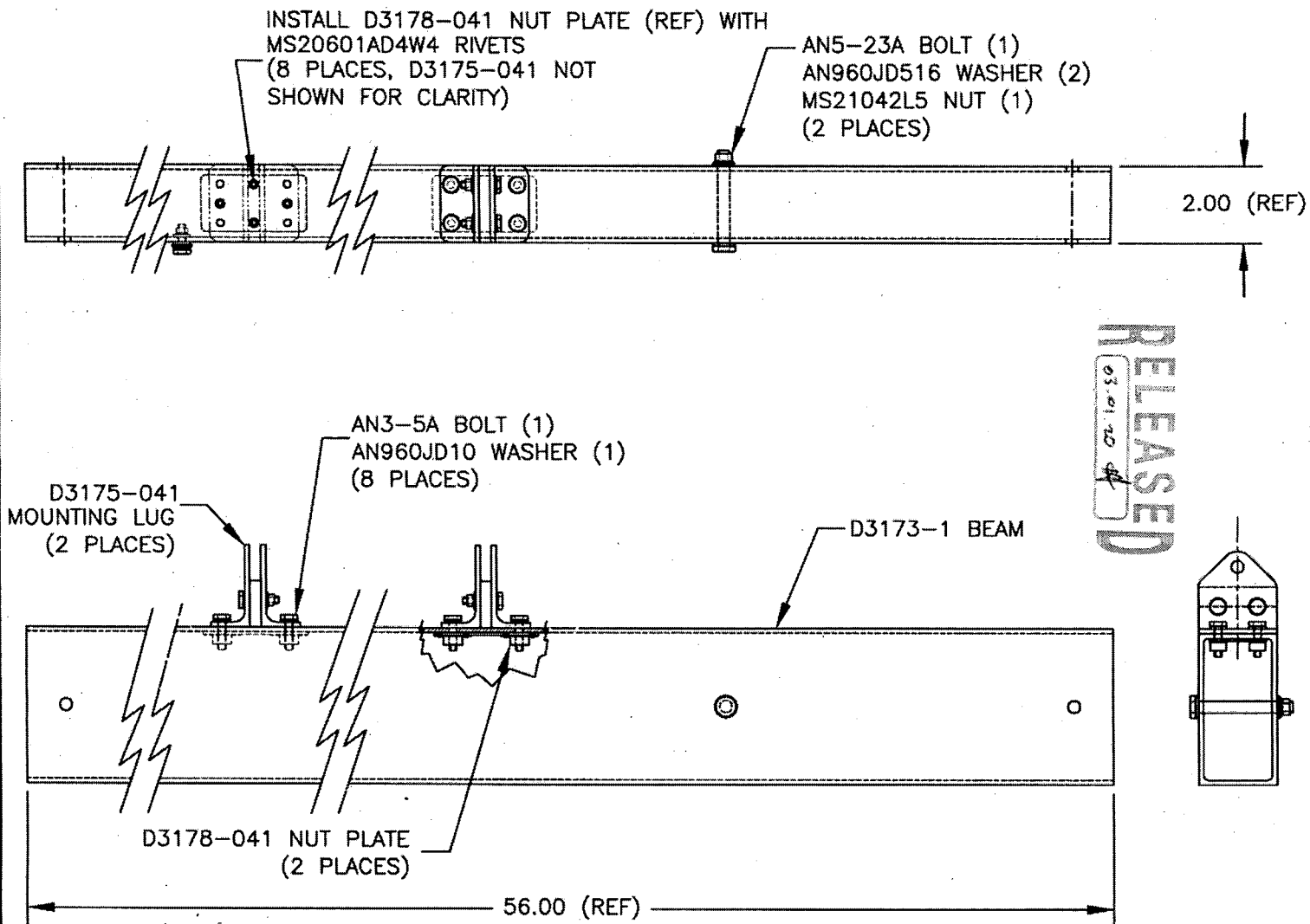
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. B	
DATE 03.01.07		D3173	SHEET 2 OF 3	
		TITLE	SCALE	
		BEAM ASSEMBLY	1:4	

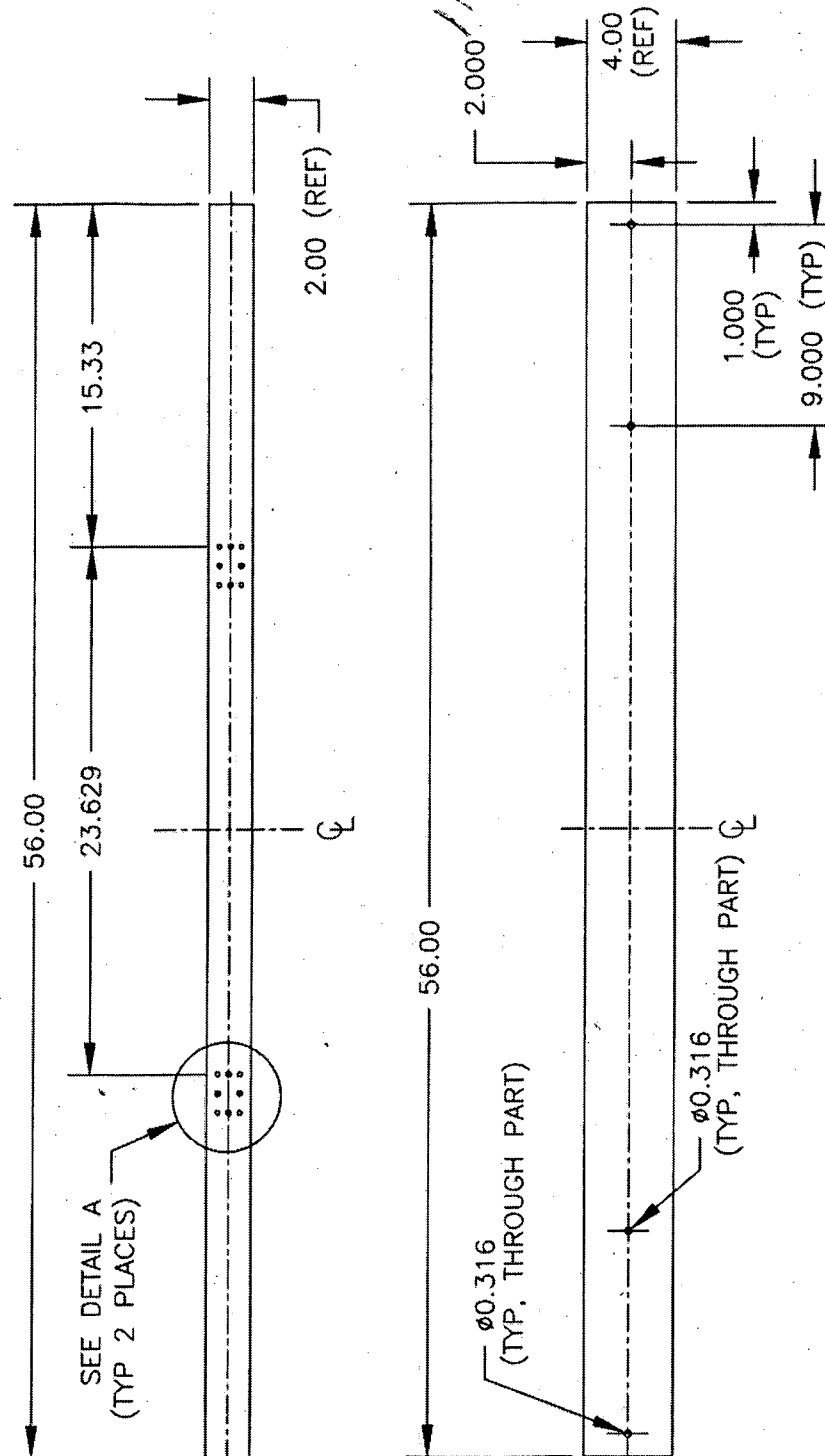


D3173-041 BEAM ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO. 41268

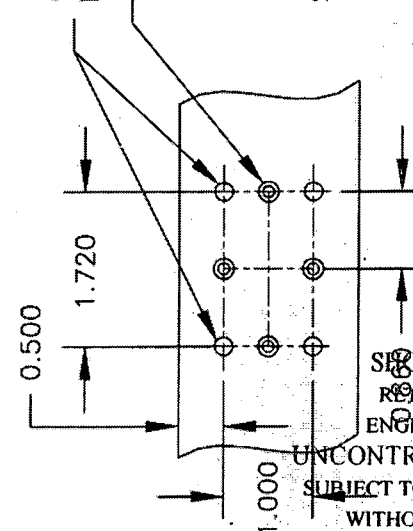
DART

DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3173	REV. B SHEET 3 OF 3
DATE 03.01.07		TITLE BEAM ASSEMBLY	SCALE 1:8

RELEASED
03.01.20**D3173-1 BEAM**

Ø0.203 (TYP 8 PLACES TOTAL,
DRILL THIS SURFACE ONLY)
DRILL #30 (Ø0.129)
C'SINK Ø0.235x100.
(TYP 8 PLACES TOTAL,
DRILL THIS SURFACE ONLY)

DETAIL A
SCALE 1:2



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